

6-7. Cutting Speed

Mild Steel

Arc Current	Material Thickness		Recommended Cut Speeds	
	Inches	mm	IPM	mm/min
40	18ga (0.05)	1.2	455	11,557
	16ga (0.06)	1.5	438	11,125
	14ga (0.08)	1.9	275	6,985
	1/8 (0.13)	3.2	195	2,311
	3/16 (0.19)	4.8	91	1,549
	1/4 (0.25)	6.4	61	254
60	1/4 (0.25)	6.4	105	2,667
	3/8 (0.38)	9.5	54	1,372
	1/2 (0.50)	12.7	34	684
	5/8 (0.63)	15.9	27	686
	3/4 (0.75)	19.1	18	457
	7/8 (0.88)	22.2	10	254

Stainless

Arc Current	Material Thickness		Recommended Cut Speeds	
	Inches	mm	IPM	mm/min
40	14ga (0.08)	2.0	221	5,613
	12ga (0.11)	2.7	189	4,800
	1/8 (0.13)	3.2	111	2,819
	3/16 (0.19)	4.8	81	2,057
	1/4 (0.25)	6.4	52	1,321
60	1/4 (0.25)	6.4	119	3,023
	3/8 (0.38)	9.5	61	1,549
	1/2 (0.50)	12.7	42	1,067
	5/8 (0.63)	15.9	28	711

Aluminum

Arc Current	Material Thickness		Recommended Cut Speeds	
	Inches	mm	IPM	mm/min
40	16ga (0.06)	1.6	327	8,305
	3/32 (0.09)	2.3	237	6,020
	1/8 (0.13)	3.2	177	4,496
	3/16 (0.19)	4.8	81	2,057
	1/4 (0.25)	6.4	52	1,321
60	1/4 (0.25)	6.4	119	3,023
	3/8 (0.38)	9.5	61	1,549
	1/2 (0.50)	12.7	42	1,067
	5/8 (0.63)	15.9	28	711

☞ Recommended cut speed is approximately 80% of maximum.

☞ Recommended maximum piercing capacity is 7/16 in. (11 mm).